

NCR-19-7756



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5149-043W
Job Sheet 198275



Part No: D5149-043W

Job Qty: 4 pcs

DAS
21
9-89

Part Name: Aft Step Base Assembly Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 9/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 4 IPP REV:A 14.12.15 NEW ISSUE DD VERF;JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	4 pcs	9/6/19	9/6/19	0.00	3.45	Large Fab - 1		AUG 2 8 2019
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	4 pcs	9/6/19	9/6/19	0.00	0.00	QC 9 - 10		DAS 43 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	4 pcs	9/6/19	9/6/19	0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



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Container No: S209836



Part: D5149-043W

Job No: 198275

Serial No/Batch: S209836

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/28/19

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P.T.O.

140 Handfinish - 1-1 Chemical- B4B	4 pcs	9/6/19	0.00 0.53	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	4 pcs	9/6/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	

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					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160	Powdercoat - 1 White Gl(A)- B4B	4 pcs	9/6/19	0.00 0.09	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	4 pcs	9/6/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Handfinish - 3-1- WingWalk- B4B	4 pcs	9/6/19	0.00 0.53	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
190	QC 3	4 pcs	9/6/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	

					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61	DAS	
					QC 3 - 81	61	
						9-89	
200	Packaging 3-1 - Stock - B4B	4	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B		
	pcs				Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B	DAS	
					Packaging 3 - 9 - B4B	30	
						9-89	
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		
					Packaging 3 - 32 - B4B		
					Packaging 3 - 33 - B4B		
					Packaging 3 - 34 - B4B		
					Packaging 3 - 35 - B4B		
					Packaging 3 - 36 - B4B		
210	QC 21 - SA	4	9/6/19	0.00 0.00	QC 21 - SA - 21		
	pcs				QC 21 - SA - 70	DAS	
					QC 21 - SA - 53	21	
						9-89	

Part Op 110 - Large Fab 2 (Weld per dwg A/R Aluminum rod Batch: 1001138872)

Descriptions: 120 - QC9 (QC9- Inspect visual per QSI004- Fusion Welds)

130 - QC5 (QC5- Inspect part completeness to step on W/O)

140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

150 - QC7-4 (QC7-Inspect Chemical Conversion Coat)

160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)

170 - QC3 (QC3- Inspect Part Finish)

180 - HandFinish3 (Wing Walk as per dwg QSI005 4.4 Batch: 5208362)

190 - QC3 (QC3- Inspect Part Finish)

200 - Packaging3-2 (Identify as per dwg & Stock Location: W 197777)

210 - QC21 (QC21- Final Inspection - Work Order Release)

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SEP 12 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5149-5	Step Cap	4 pcs (1 ea)	110-Large Fab - Welded Assy-1	5150644 → 1 5209308 → 3
D5149-7	Aft Step Base	4 pcs (1 ea)	110-Large Fab - Welded Assy-1	5146807 → 3 5187584 → 1
D5149-9	Aft Step	4 pcs (1 ea)	110-Large Fab - Welded Assy-1	5146943 → 13 5122358
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D5149-5	4	1	0
	D5149-7	4	13	0
	D5149-9	4	12	0
Part Specifications				
Specifications could not be found.				

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Entered: TK Date: Nov 19/19

NCR No. 19-7756

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

Job: <u>198275</u> <u>S-209836</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☒ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
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Date: <u>30 aout 2019</u>	Sequence #: <u>110</u>	QTY Affected: <u>Yes 10 of 4</u>	MRB (QSI042) <u>INSP 12</u> <u>CP 19/8/30</u>
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Description Work Order Deviation <u>- scrap / destroy</u>	Disposition <u>- D5149-7 a craquer durant le soudage.</u>	Completed By <u>DAS 43</u> <u>9-89</u>
		Lead hand / Supervisor <u>EL</u>
		QC / QA Coordinator <u>DAS 68</u> <u>9-89</u> <u>AUG 30 2019</u>

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	Pressure/Forced ☐ Bending ☐ Crushing ☐ ☒ Cracks Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
Other/Details:				